

Date: Monday, 2/19/2007 8:07:25 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 30746	
Estimate Number : 12668	
P.O. Number : <u>N/A</u>	Part Number : D323835
This Issue : 2/19/2007 S.O. No. <u>N/A</u>	Drawing Number : D3238 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30689	Material : <u>N/A</u>
Written By : _____	Due Date : 2/26/2007 Qty: <u>32</u> Um: Each
Checked & Approved By : <u>07.02.19</u>	
Comment : Est Rev:A New Issue 07-01-26 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S020	6061-T6 .020 Sheet
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Comment: Qty.: 0.0252 sf(s)/Unit Total : 0.8064 sf(s)

6061-T6 .020 Sheet

Batch: M4894

5052-220

SAD 07/02/19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3238

Dwg Rev: B

Prog Rev: B

SAD 07/02/19 (32)

2-Deburr if necessary

Use cutting file D3238-21-23-25**

MF 07-02-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/19 (32)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S.F. 07/02/19 (32)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

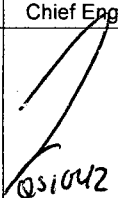



M.F. 07/02/20 (32)

07/02/20 (32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/19	2.0	3 pieces were scrap (2) because of program and (1) mixing tube had to be change	 QSI042	destroy & replace. Adjust offset to achieve proper dims.	SAD 07/02/19	 070219	 QSI042	 070219

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:25 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 30746

Part Number: D323835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/2/21 (32)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5 PC 7/2/21 (32)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(32)
07/02/22

Job Completion



U 02.02.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

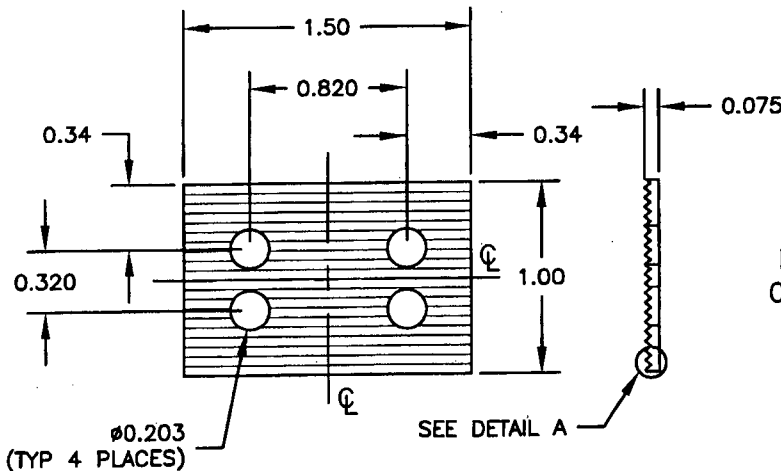
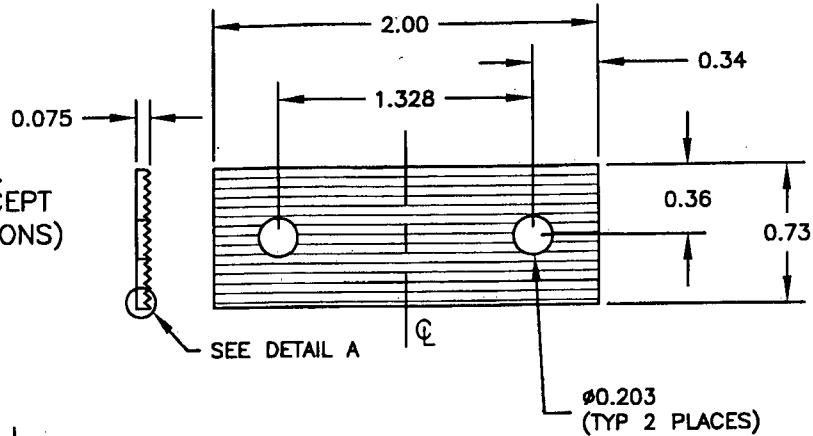
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 1 OF 3
DATE 07.01.17	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	

D3238-1 PLATE (SHOWN)
D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)
D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

RELEASED

07.01.22 #

NOTES:

- MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 004 4.1
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- SEE SHEET 3 FOR DETAIL A
- PARTS ARE SYMMETRIC ABOUT ϕ

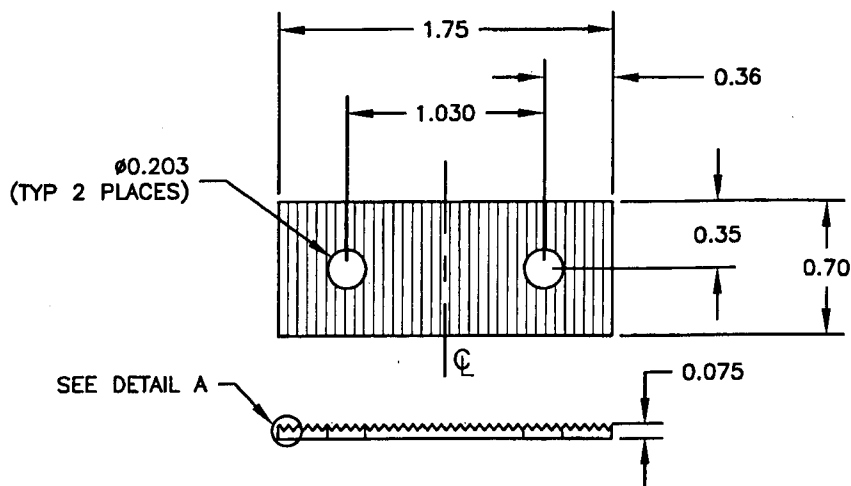
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WORK ORDER
NO. 30746

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DART

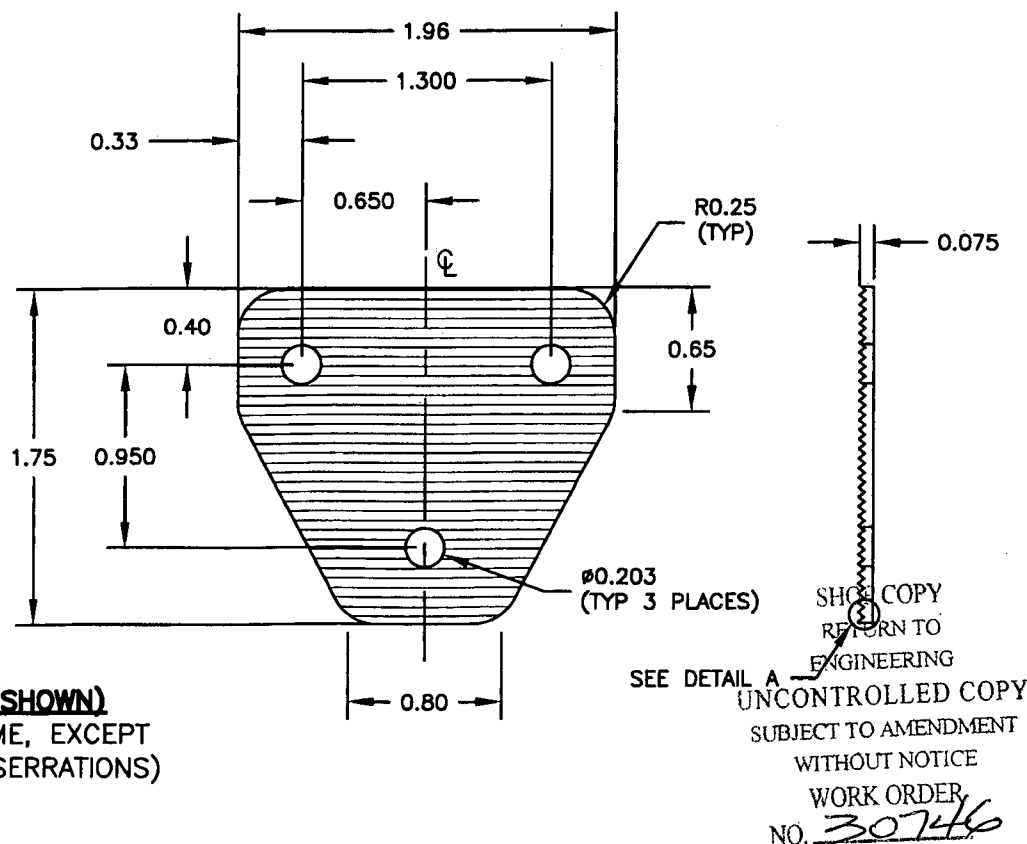
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CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 2 OF 3
DATE 07.01.17	TITLE PLATE		SCALE 1:1



D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

RELEASED

07.02.12



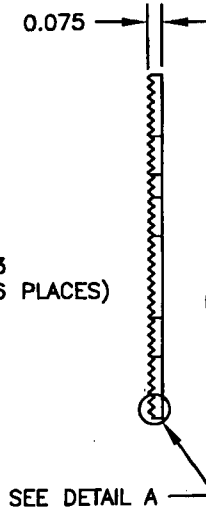
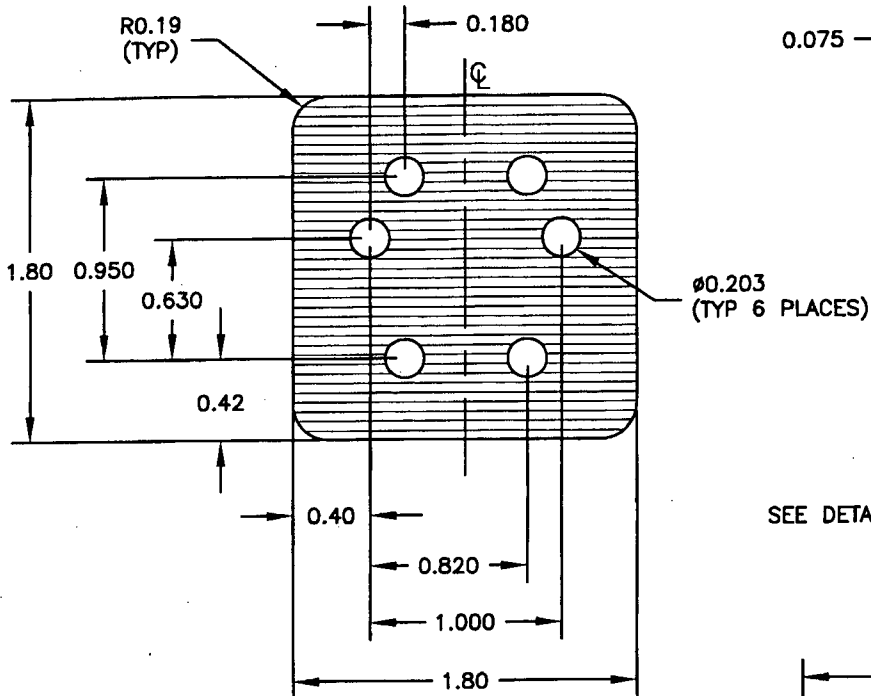
D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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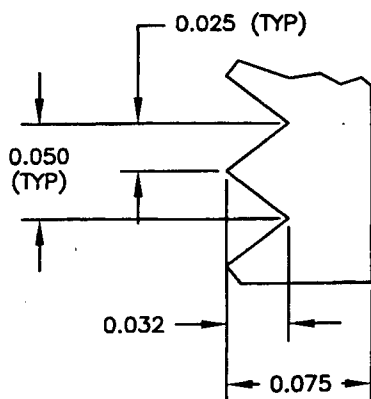
DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. B SHEET 3 OF 3
DATE 07.01.17		TITLE PLATE	SCALE 1:1

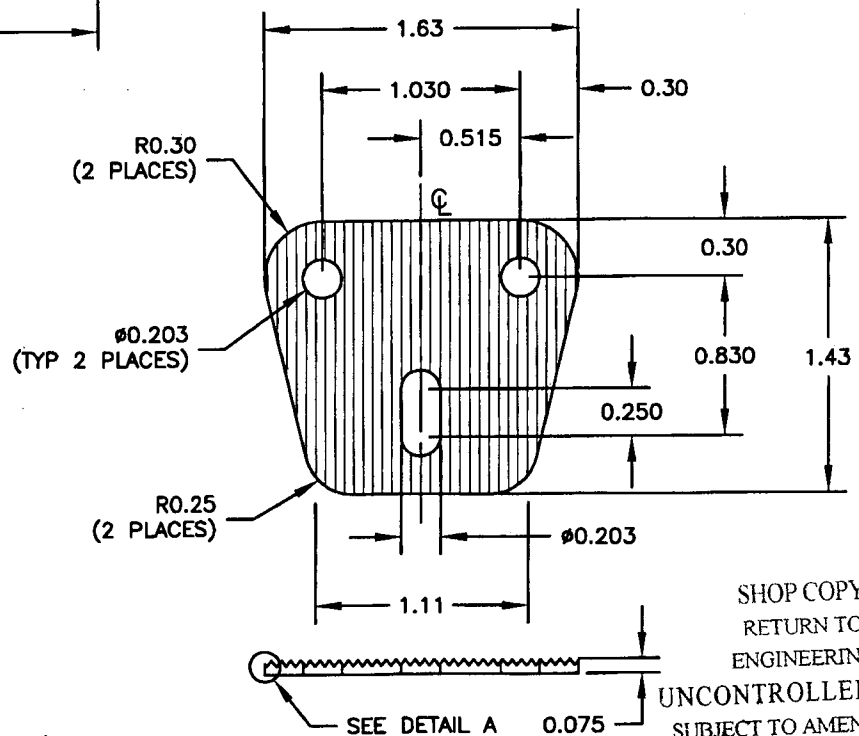
**RELEASED**

07.01.22

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

**DETAIL A**

RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT NO.
0.020 THICK AND NO SERRATIONS)

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